

Date: Tuesday, 11/27/2007 7:45:26 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CLAMP  
 Job Number : 35979  
 Estimate Number : 10351  
 P.O. Number :  
 This Issue : 11/27/2007 S.O. No. :  
 Prsht Rev. : NC Part Number : D30413  
 First Issue : 11 Type : MACHINED PARTS Drawing Number : D3041 REV.C  
 Previous Run : 30890 Drawing Revision : C  
 Material :  
 Due Date : 12/12/2007 Qty: 40 Um: Each  
 Written By :  
 Checked & Approved By : *[Signature]*  
 Comment : Est:A 01.07.11 New Issue SM/EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.1094 f(s)/Unit Total : 4.3764 f(s)  
 Lug Extrusion  
 (D2423) Batch: 33310

2.0 BAND SAW BAND SAW



Comment: BAND SAW  
 Cut D2423 Extrusion: 1.250" Long

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
 Check for cracks while loading into the machine  
 Machine as per ~~Foto FA153~~ and Dwg D3041  
 Tumble and Deburr rough edges after tumbling  
 Identify as D3041-3

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE  
*Receive & inspect for transit damage*

5.0 QC5 SECOND CHECK



Comment: SECOND CHECK  
*Inspect levels*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CLAMP

Job Number: 35979

Part Number: D30413

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL 08-03-01 (X40)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask inside of 0.8120" diameter hole

HL 08-05-04 (H0)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-H 08/03/04 (40X)

9.0

D2611

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Bearing

Pick:

Qty Part Number Description Batch  
1 D2611 Bearing

31888 8/3/5 SQ (40X)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Press D2611 bearing into lug as per Dwg D3041

2- Stake bearing into place as per Dwg D3041

3-Touch up stake marks with white emeron paint

x40 ml 08/03/07

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/10 (X40)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 465

8/3/10 SQ (40X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   A   Date: 08/03/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 35979

Part Number: D30413

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(40)

Comment: FINAL INSPECTION/W/O RELEASE

Aug 103/11

Job Completion



mi 2008/3/10

(40)

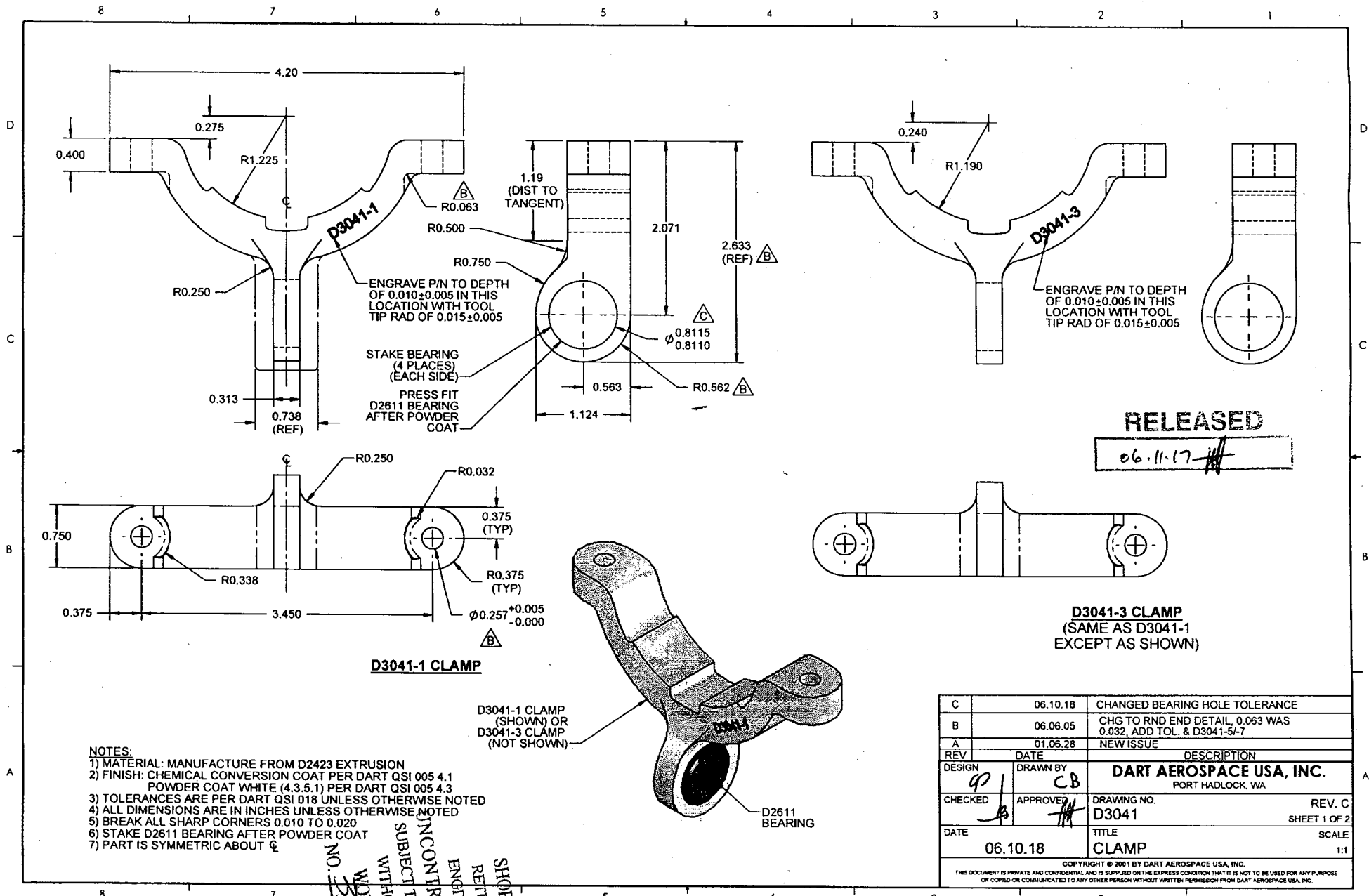
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED

06.11.17

**D3041-3 CLAMP**  
(SAME AS D3041-1  
EXCEPT AS SHOWN)

**D3041-1 CLAMP**

D3041-1 CLAMP  
(SHOWN) OR  
D3041-3 CLAMP  
(NOT SHOWN)

D2611  
BEARING

- NOTES:
- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
  - 6) STAKE D2611 BEARING AFTER POWDER COAT
  - 7) PART IS SYMMETRIC ABOUT C

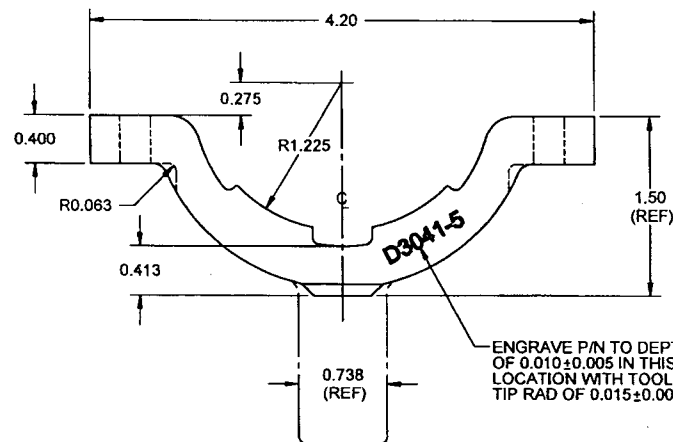
NO. 35479  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

C	06.10.18	CHANGED BEARING HOLE TOLERANCE	
B	06.06.05	CHG TO RND END DETAIL, 0.063 WAS 0.032, ADD TOL. & D3041-5/-7	
A	01.06.28	NEW ISSUE	
REV	DATE	DESCRIPTION	
DESIGN	DRAWN BY	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. <b>D3041</b>	REV. C
DATE	06.10.18	TITLE <b>CLAMP</b>	SHEET 1 OF 2
		SCALE 1:1	

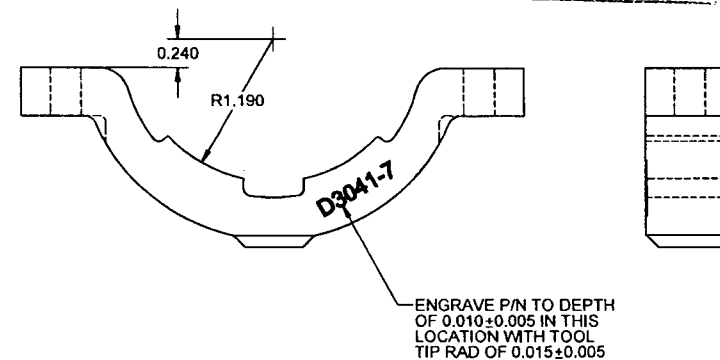
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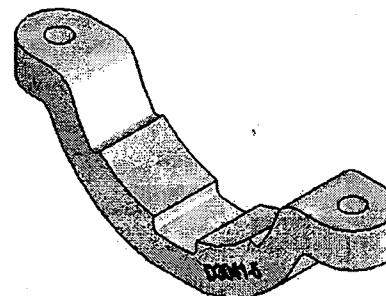
06.11.17



D3041-5 CLAMP



D3041-7 CLAMP  
(SAME AS D3041-5  
EXCEPT AS SHOWN)



- NOTES:
- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
  - 6) PART IS SYMMETRIC ABOUT  $\phi$

NO. 35279  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
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RETURN TO  
SHOP COPY

DESIGN GP	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED B	APPROVED H	DRAWING NO. D3041	REV. C
DATE 06.10.18	TITLE CLAMP	SHEET 2 OF 2 SCALE 1:	
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## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:


same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
21	D3041-1	Lug B35978	5154
40	D3041-3	Lug B35979	5154

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

  
Shigi Walz

Vankleek Hill, March 3, 2008